

# Work Order ID 64474

December 6, 2010 12:41:40 PM

Page 1

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Setup Start

Stop

Start Date: 12/06/10 Start Qty: 1.00

Required Date: 12/17/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00

DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

Sub 2/01

11-01-02

110

0.00

CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

10-12-8

# Work Order ID 64474

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

3 BE 10/12/13

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 10/12/13

70



# Work Order ID 64474

December 6, 2010 12:42:15 PM



Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004  
A/R Aluminum Rod

*M15778 BE 10/12/13*

2-Grind welds on step as per Dwg D2580

*BE 10/12/13*

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091. open to .640" and Debur

*BE 11/01/28*

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*Sub 131*

# Work Order ID 64474

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

No paint Alodine only

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BR 11-01-31

# Work Order ID 64474

December 6, 2010 12:42:20 PM



Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates  
A/R 11/11/10 Sikaflex-291  
Sikaflex expire date: 11/01/11

Wearplates + gaskets to be shipped in kit

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

=> 11/01/11

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R 11/11/10 Sikaflex-291 11/15/11  
Sikaflex expire date: 11/01/11

11/01/11  
11/01/11  
11/01/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: 11/01/11

11/01/11

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0.00

Sub 11/31



220

Packaging

0.00



Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

0.00

210B Pick kit

210B - 24 Sub 11/31

11/21/10



11/21/10

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/02/01

ME 11-02-01



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Page 1

**Parent Item:** D205-634-041

**Parent Item Name:** Replacement Skidtube



**Start Date:** 12/06/10

**Required Date:** 12/17/10

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30  
KJ IPP Rev P 10.02.19  
per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 		Manufactured	No			140	Each	0.0000	20	20		BE 11/01/28	
Spacer D2580-1 		Manufactured	No			110	Each	5.0000	1	1		B 6460.8	(x20)

205 Skidtube bent detail

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	4	
63050	2	
63051	2	
ST046	1	
59856	1	

D2576-3	Manufactured	No	140	Each	64.0000	1	1
							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	64	
46661	16	
52215	48	

Step (maching detail)

① = 10-12-8

1 8E 10/12/13

# Picklist Print

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Page 2

Work Order ID: 64474

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 12/06/10

Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

54.0000

1

1



Cap



11/01/31

Location

Loc Qty

Loc Code

FP6

3

56613

1

63634

2

ST026

51

50513

1

50770

28

51539

2

53791

20

x1

AN3-5A

Purchased No

200

Each

1,221.000

2

2



Bolt



11/01/31

Location

Loc Qty

Loc Code

ST350

1221

105057

221

115016

500

115371

500

x2

AN960JD10L

NAS1149D03321 Purchased

No

200

Each

0.0000

2

2



Washer



M116441

x2 11/01/31

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 64474

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 12/06/10

Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,628.000

50

50



Insert

## Location

## Loc Qty

## Loc Code

FP

689

M116079

X50 21 11/01/31

115079

689

ST282

939

113238

17

115502

500

115581

422

AN3C4A

Purchased

No

200

Each

1,885.000

50

50



BOLT

M116590 11/2/10

## Location

## Loc Qty

## Loc Code

ST303

3

115438

3

ST350

1882

115300

42

115936

840

116075

1000

AN960C10L

NAS1149C0332

Purchased

No

200

Each

25.0000

50

50



washer

M116025 11/2/10

## Location

## Loc Qty

## Loc Code

ST245

25

107534

25

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Page 3

# Picklist Print

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Page 4

Work Order ID: 64474

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 12/06/10

Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

D3566-13



Gasket

Manufactured No 200 Each 33.0000



11/21/10

Location Loc Qty Loc Code

FP012 13

60209 1

61996 12

FP014 20

64070 20

D3566-5



Gasket

Manufactured No 200 Each 19.0000



B64789 11/21/10

Location Loc Qty Loc Code

FP015 19

62463 9

63574 10

D3566-1



Gasket

Manufactured No 200 Each 22.0000



11/21/10

Location Loc Qty Loc Code

FP015 22

57715 2

61992 1

62892 7

63573 12

D3564-11



Wearshoe

Manufactured No 200 Each 14.0000



11/21/10

Location Loc Qty Loc Code

FP019 14

62236 14

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Shop Packet Print

Page 4

# Picklist Print

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Page 5

Work Order ID: 64474

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 12/06/10

Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

26.0000



Wearshoe



11/16/10

Location

Loc Qty

Loc Code

FP17

26

59660

1

60862

4

61828

9

62229

12

D3564-9

Manufactured No

200

Each

23.0000



Wearshoe



11/16/10

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

7

61709

7

FP19

15

62238

15

D3564-5

Manufactured No

200

Each

27.0000



Wearshoe



11/12/10

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

24

62237

12

63575

12

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Shop Packet Print

Page 5

# Picklist Print

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Page 6

Work Order ID: 64474

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 12/06/10

Required Date: 12/17/10

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200 Each

795.0000 16

16



O-Ring, 205 Skidtube



11/01/31

11/01/31

## Location

## Loc Qty

## Loc Code

FP

43

B62843

X16

55546

19

58191

12

B61762

59358

12

fpa

752

61762

752

D2594-1

Manufactured No

200 Each

235.0000 16

16



Plug, 205 Skidtube



## Location

## Loc Qty

## Loc Code

FP

183

42807

112

55002

71

FP14

52

58434

15

62892

37

11/01/31

X16

December 6, 2010 12:41:40 PM

Shop Packet Print

Page 6

**DART****RELEASED**  
07-06-28 #**DEO ATTACHED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64874  
*BS10-12-2*

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



who was <sup>18</sup>18



Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

RELEASED  
07-06-28

**DEO ATTACHED**

Technical drawing of a circular base plate with a central hole and a vertical rod passing through it. The drawing includes dimension lines and labels for various components and materials:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two locations on the base plate where drilling is required.
- AN3-SA BOLT (1)**: Points to the bolt passing through the base plate.
- AN960JD10L WASHER (1)**: Points to the washer between the bolt and the base plate.
- (2 PLACES)**: Points to two locations on the base plate where the washer is installed.
- D2855 CAP**: Points to the cap of the bolt.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied around the bolt head.
- 0.40**: Dimension line indicating the distance from the center of the bolt to the edge of the base plate.

Diagram of a circular component with the following labels:

- D2579 SPACER
- D2596 WEB (REF)
- AL57-1032-130 (REF) (TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2596 SPACER TO #0.437 X 1.00 DEEP

[illegible]

0.5 1.5 1.5 0 0

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

8

1.5 1.5 1.5

REFER TO DETAIL C

D3566-1 D3566-5 D3566-13 D3564-11 D3564-5 D3564-9 D3564-13

AN304A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

DESIGN DRAWN BY

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DART AEROSPACE LTD.

DESIGN 	DRAWN BY 		DART AEROSPACE LTD. WILKINSBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>H</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

**PURPOSE:**

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

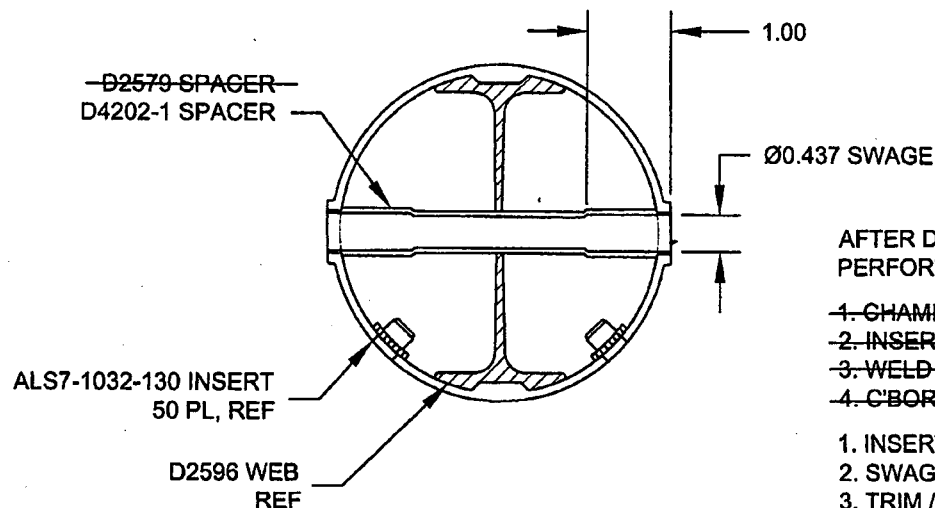
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
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SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



**SECTION D-D**  
NOT TO SCALE

**SECTION H-H**  
NOT TO SCALE

**RELEASED**  
2010-11-18  
*MP*

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries